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K6A 1K7
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D4634-141
Job Sheet 185060



006734

Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV G SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY: JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Small Fab		Sm15
100	HandThermo	1 pcs		11/16/18	0.00	1.65	HandFinish4		Sm15
110	Small Fab	1 pcs		11/16/18	0.00	1.47	Small Fab		Sm15 DAS
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3		Sm15
140	QC21-SA	1 Ea		11/16/18	0.00	0.00	QC21		DEC 04 2018

Part Op 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300
Descriptions: Batch: m138775 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # m138958 Expiry Date April 2019 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m138609
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location:
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-1	Fwd, Center Ceiling Panel	1 Ea (1 ea)	90-Start up Operation	S131079
D4636-5	Bracket	1 Ea (1 ea)	90-Start up Operation	5004185
D4647-5	Doubler	1 Ea (1 ea)	90-Start up Operation	S128082
D4664-5	Spacer <u>x3 S011418</u>	6 Ea (6 ea)	90-Start up Operation	S033886 X3
D4712-1	Bracket	1 Ea (1 ea)	90-Start up Operation	S121111
D4732-15	Label	1 Ea (1 ea)	90-Start up Operation	S104125
D4732-19	Label	1 Ea (1 ea)	90-Start up Operation	S008993
D5021-1	Foam, Center Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	S123625
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	90-Start up Operation	fm130423-1
MS20426AD3-4	Rivet	4 Ea (4 ea)	90-Start up Operation	fm136444-2
MS20426AD4-6	Rivet	2 Ea (2 ea)	90-Start up Operation	S093088-1
MS21059L08	Nut	2 Ea (2 ea)	90-Start up Operation	S129976
<u>CCR26455-3-03 X4</u>				S099729
				S088912

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

90-Start up Operation

D4634-1	1	2	0
D4636-5	1	39	0
D4647-5	1	1	0
D4664-5	6	21	0
D4712-1	1	7	0
D4732-15	1	12	0
D4732-19	1	15	0
D5021-1	1	0	0
MPNY-750S-9-C	7	126	0
MS20426AD3-4	4	4,602	0
MS20426AD4-6	2	1,909	0
MS21059L08	2	138	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 12:51 PM Dart.lajeunesse.marie

DART
AEROSPACE

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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S133432



Part: D4634-141

Job No: 185060

Serial No/Batch: S133432

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/03/18

DQA: _____ Date: _____



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